

Work Order ID 62777

Friday, October 08, 2010 8:02:50 AM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:						
Item Name:	350 Basket Base				Stop	
Start Date:	10/8/2010	Start Qty:	1.00			
Required Date:	10/15/2010	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	10.12.08	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								
100		0.00							
	Large Fab								
Large Fab		0.00							
Large Fab	Memo								
	1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221								
	2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221								
	3- tack weld mesh on basket as per dwg D2221								
	A/R ER316 S.S. Rod Batch: 111585								
110		0.00							
	QC9- Inspect visual per QS1004- Fusion Welds								
QC		0.00							
Quality Control	Memo								

Pl 10.12.13

BE
Pl 10.12.13

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 10/8/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

8 10/12/13



Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

1 BK 10-18-14

Hand Finishing

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Page 3

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Powdercoat

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

Powder Coating

Memo

1- Plug holes prior to

0.00

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*****2nd coat if necessary*****

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1 10-12-14.

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

4510/12/15

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

G-A
w/o 62774

0.00

Packaging

EPB 10/12/15

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/16
MF
10-12-15

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Friday, October 08, 2010 8:02:54 AM

Page 1

ALL INFORMATION CONTAINED HEREIN IS UNCLASSIFIED
DATE 08-28-2001 BY 60322 UCBAW









Required Date: 10/15/2010

Required Qty: 1.00

Comments:

IPP Rev:J	05.09.02	Added D3442-1	□KJ/JLM	
IPP Rev:K	08-08-29	revG as per dwg	DD	verified by:EC
IPP Rev:L	08-09-24	plug holes prior to powder coat	DD	verified by:EC
IPP Rev:M	08-12-02	revI as per dwg	DD	verified by:EC
	10.06.29	added pressure wash	DD	verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 		Manufactured	No			100	Each	14.0000	1	1			
Rib										Pl 10.12.08			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				14		B63628	→	①	
				61091				2					
				61424				12					
D2221-5 		Manufactured	No			100	Each	12.0000	2	2			
Rib										Pl 10.12.08			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				12		B62996	→	②	
				60957				4					
				61753				8					
D2221-7 		Manufactured	No			100	Each	6.0000	1	1			
Rib										Pl 10.12.08			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				6		B62997	→	①	
				61180				2					
				61754				4					

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Picklist Print

Friday, October 08, 2010 8:02:54 AM

Page 2

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Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3
Basket Hinge

Manufactured No

100 Each

8.0000

2

Location

Loc Qty

Loc Code

WA

8

61182

2

61755

6



Pl 10.12.08

B63878 → (2)

D2235-1
Basket Rib

Manufactured No

100 Each

16.0000

2

Location

Loc Qty

Loc Code

WA

16

61471

6

62254

10



Pl 10.12.08

B64250 → (2)

D2581
Mounting Bracket

Manufactured No

100 Each

51.0000

2

Location

Loc Qty

Loc Code

WA

51

60470

31

61953

20



Pl 10.12.08

(2)

D3442-1
Shim

Manufactured No

100 Each

16.0000

2

Location

Loc Qty

Loc Code

WA

16

60177

4

61181

12



Pl 10.12.08

B63002 → (2)

Friday, October 08, 2010 8:02:54 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Picklist Print

Page 4

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Work Order ID: 62777



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

14.0000

2

2



Mesh (Base End Face)

Pl 10.12.09

Location

Loc Qty

Loc Code

WA

14

61285

6

62383

8

B63255 → (5)

Friday, October 08, 2010 8:02:54 AM

Shop Packet Print

Page 4

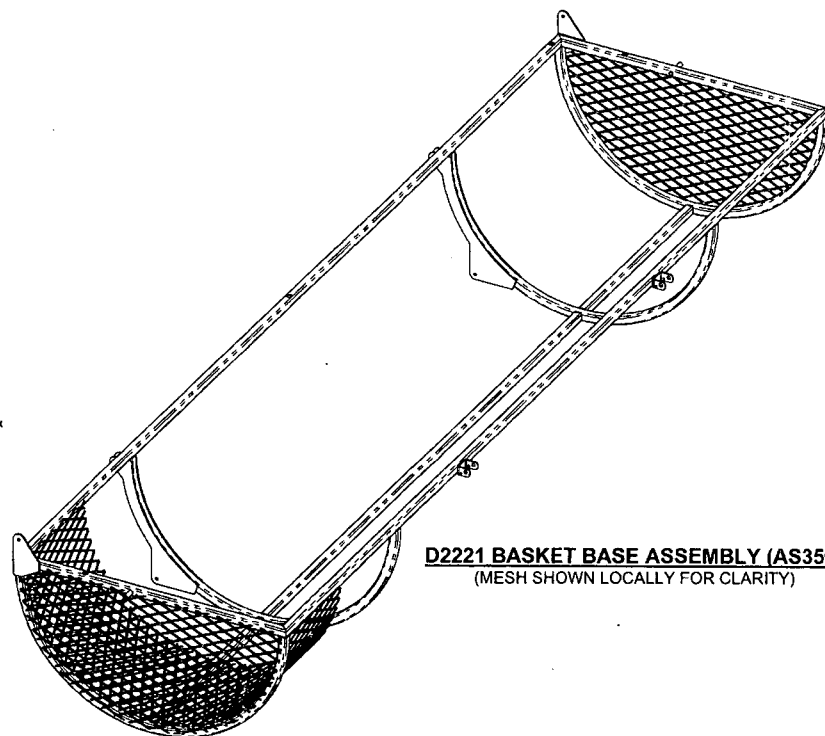
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
06/11/18

SHOP COPY
REVISION
ENGINEER
UNCONTROLLED COPY
SUBJECT TO
WITH
WORK
NO. 62777
Photo 58

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 42.00 lbs APPROX
 - 8) MASK ALL HOLES PRIOR TO POWDER COATING

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JS		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

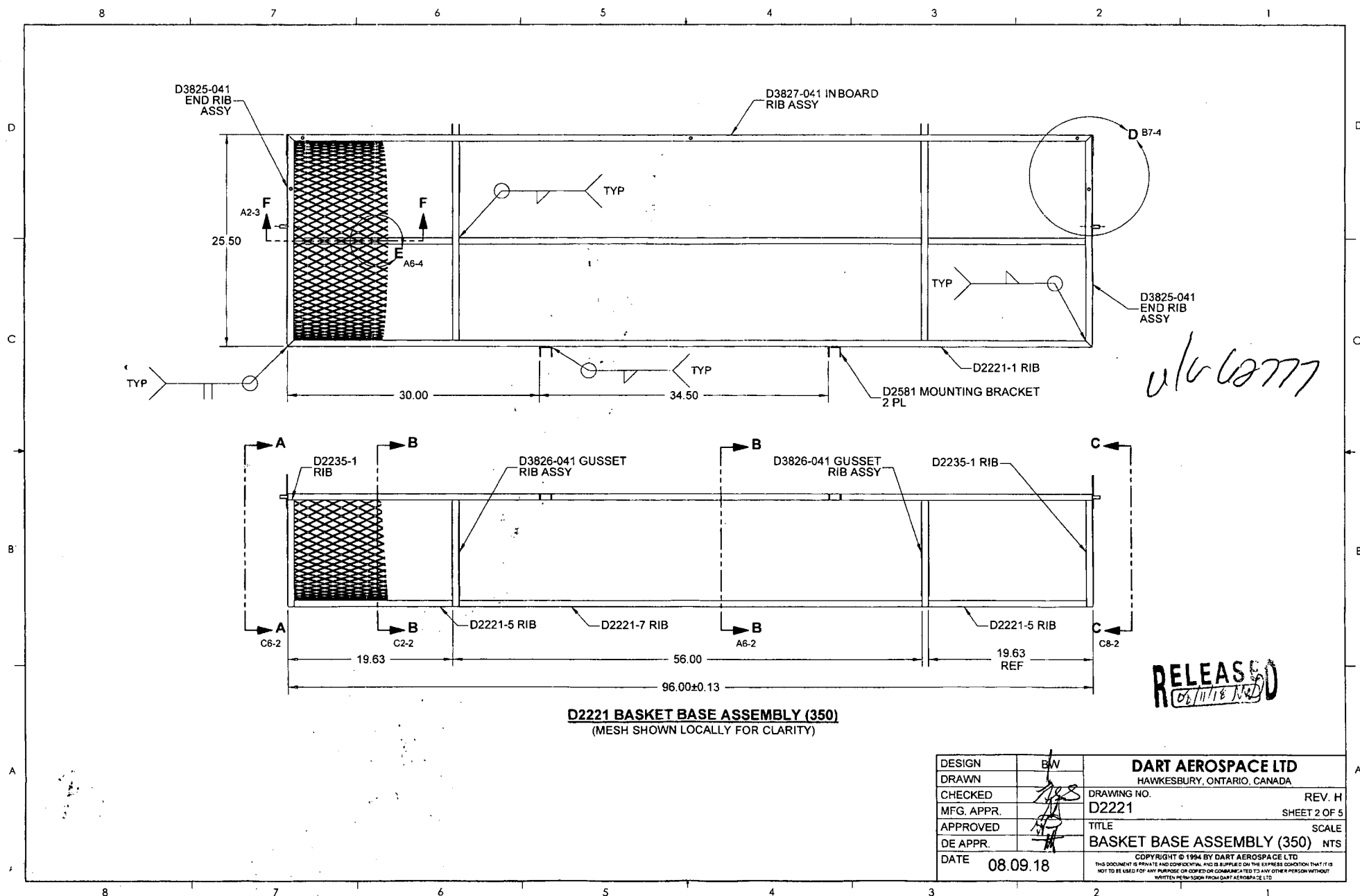
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NOTE: Date & initial all entries



DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

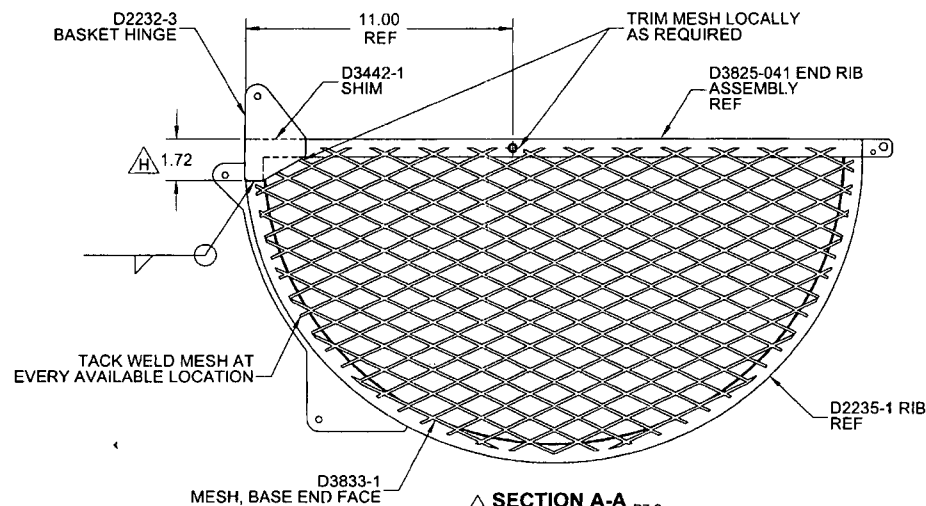
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

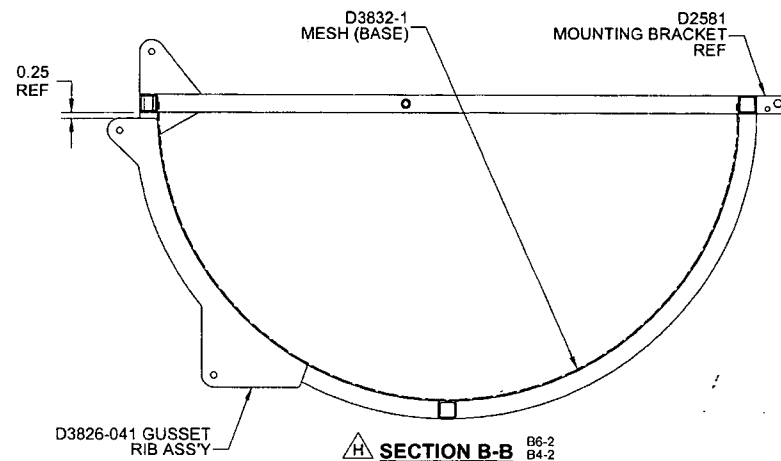
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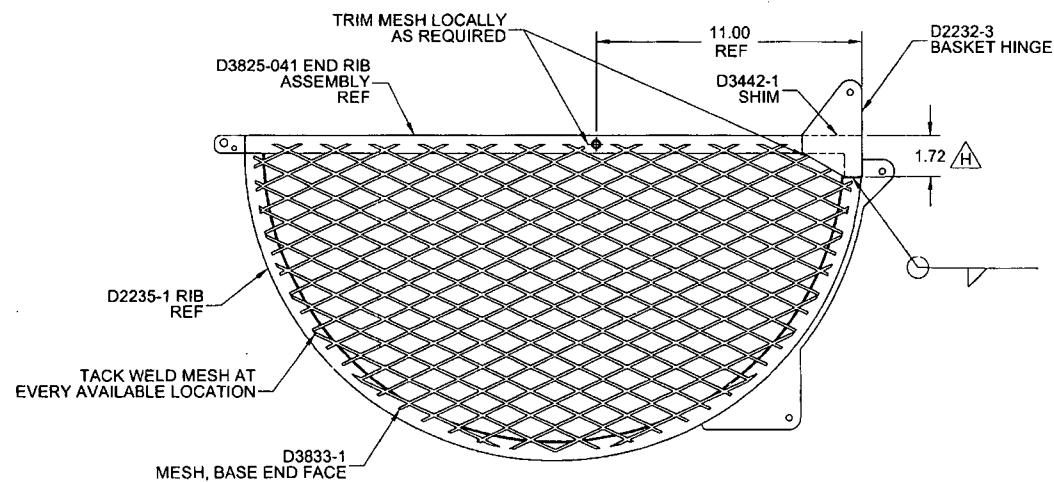
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SECTION A-A
SCALE 2X B7-2



SECTION B-B
SCALE 2X
(D3833-1 MESH NOT SHOWN FOR CLARITY)
B6-2
B4-2



SECTION C-C
SCALE 2X B2-2

u62777

RELEASED
03/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	433	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	1/1	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

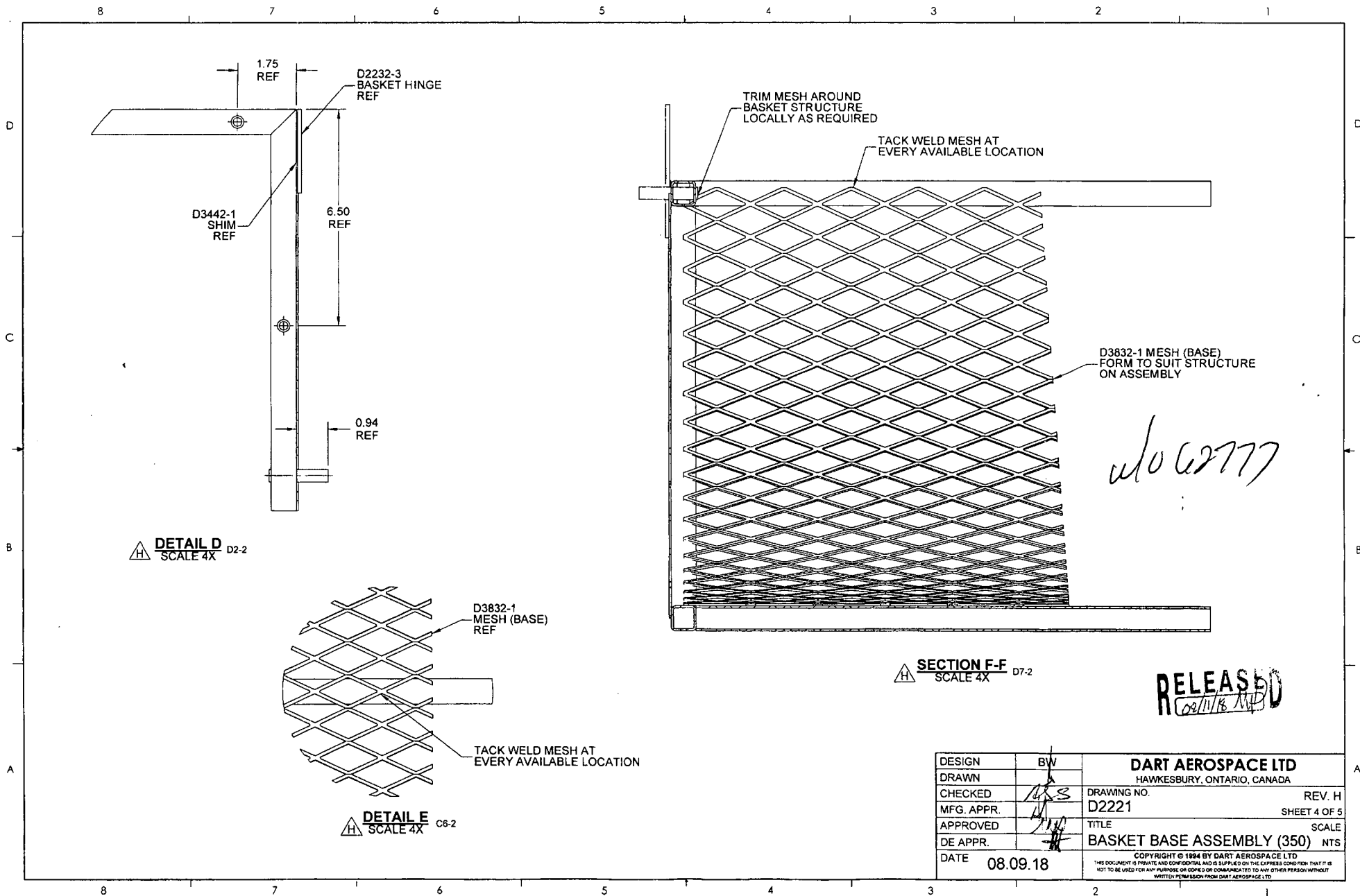
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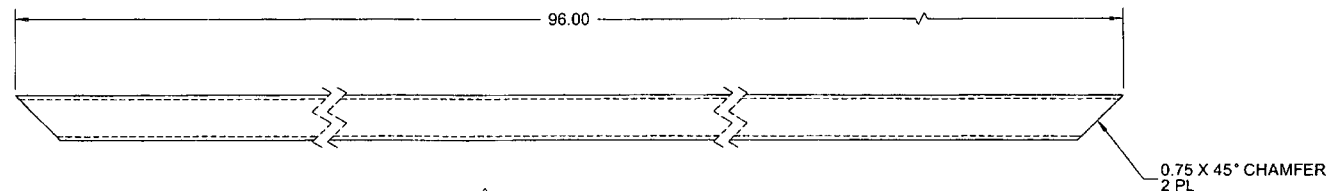
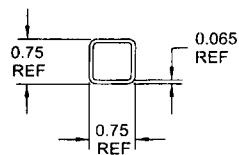
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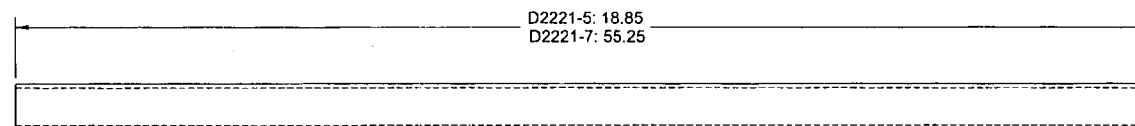
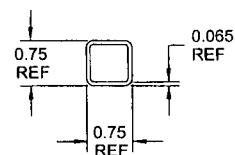
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D2221-1 RIB



D2221-5/-7 RIB

W/O 62777

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AS	DRAWING NO.	REV. H
MFG. APPR.	AD	D2221	SHEET 5 OF 5
APPROVED	W	TITLE	SCALE
DE APPR.	W	BASKET BASE ASSEMBLY (350)	NTS
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